Shy Machine 07/04

Work Order ID 109464

109464

November-21-13 2:28:29 PM

Item ID: D2012-105 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Arm (31.06)

Start Date: 11/21/13 **Start Qty:** 2.00 *2*

Required Date: 11/21/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MCS **Date:** 13-11-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2012-105	E								
100		0.00							
100	NC BRAKE					2			FF 14-04-04
Brake NC	**Memo**	0.00							
Brake NC	Punch to length as per Dwg D2012-105 & template D2012-105T1								
110		0.00							
110	Small Fab					2			FF 14-04-04
Small Fab	**Memo**	0.00							
Small Fab	1-Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00				2			
120									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89 14/4/4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D2012-105 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Arm (31.06)
Start Date: 11/21/13 **Start Qty:** 2.00 *2*
Required Date: 11/21/13 **Req'd Qty:** 2.00 *2*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 AM126878	0.00				x2	d	11	11/04/07
130									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 9:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 10:00AM								
140	QC3- Inspect Part Finish	0.00				2			
140									
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 1XST227	0.00				2x			
150	1x Ship								
Packaging	**Memo**	0.00							
Packaging									

DAS 27 9-89 — 14/4/3

DAS 28 9-89 — APR 07 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
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General

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☐ BOM/Route
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☐ Burrs
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☐ Countersink
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☐ Drawing
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☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D2012-105 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Arm (31.06)
Start Date: 11/21/13 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 11/21/13 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160							RC 11-04-7		
QC	**Memo**	0.00							
Quality Control									

MF 11-4-13

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
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General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
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☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Out of Calibration
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☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

November-21-13 2:28:29 PM

Work Order ID: 109464

Parent Item: D2012-105

Parent Item Name: Arm (31.06)

Start Date: 11/21/13 **Required Date:** 11/21/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:I02.04.03Added Inspect level 3NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	294.7058	**2.6254**	**5.5271578**			

FF 14-04-04

Location	Loc Qty	Loc Code	
MAT017	294.7058225		
118702	0.00003		
123303	138.9645		
125513	86.1014525		5.5271
m126922	69.63984		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

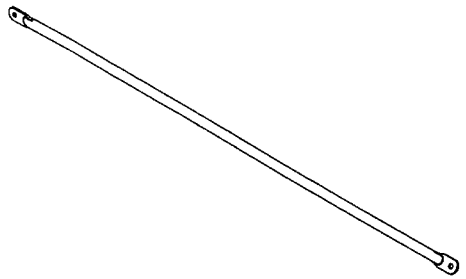
FAULT CATEGORY

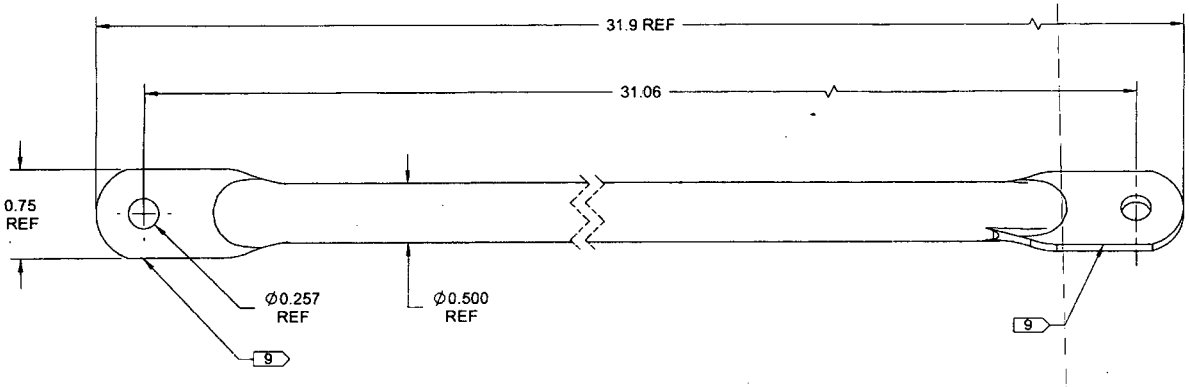
Landing Gear

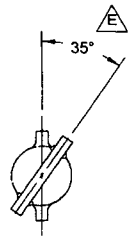
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☐ Other _____







D2012-105 ARM

RELEASED 9/6/23 MP

NOTES:
1) MATERIAL: AISI 304/316 SS TUBE Ø0.500 X 0.035 WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
7) WEIGHT: 0.47 lbs
8) MAKE PER TEMPLATE DT8116
9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-060	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2012-105 REV. E SHEET 1 OF 1
CHECKED		
MFG. APPR.		TITLE ARM SCALE NTS
APPROVED		
DE APPR.		
DATE	09.06.04	

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109464 MCJ
13-11-22

DART AEROSPACE LTD

Description: ARM Work Order: 109464

Inspection Drawing: D2012-105 Rev: E Part Number: D2012-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.90	± 0.030	31.90	✓		SFab-07	
31.06	± 0.030	31.06	✓		SFab-07	

DAS

Measured by:	Checked By: DAS 36 9-89	QC inspector: 27 9-89	Engineering Approval (*if necessary*)
FF			
Date 14-04-04	Date 14/04/04	Date 14/4/4	Date